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D4931-3

Job Sheet 188265



Part No: D4931-3

Job Qty: 12 pcs

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/19

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12		1/25/19	0.00	11.88	Doosan - 1		 DAS 5 9-89
		pcs							
110	QC 2	12		1/25/19	0.00	0.00	QC 2 - 1		 DAS 5 9-89
		pcs					QC 2 - 12		
							QC 2 - 14		 DAS 5 9-89
							QC 2 - 17		
							QC 2 - 19		 DAS 5 9-89
							QC 2 - 2		
							QC 2 - 20		 DAS 5 9-89
							QC 2 - 22		
							QC 2 - 23		 DAS 5 9-89
							QC 2 - 25		
							QC 2 - 32		 DAS 5 9-89
							QC 2 - 33		
							QC 2 - 35		 DAS 5 9-89
							QC 2 - 38		
							QC 2 - 39		 DAS 5 9-89
							QC 2 - 4		
							QC 2 - 40		 DAS 5 9-89
							QC 2 - 44		
							QC 2 - 45		 DAS 5 9-89
							QC 2 - 48		
							QC 2 - 49		 DAS 5 9-89
							QC 2 - 50		
							QC 2 - 51		 DAS 5 9-89
							QC 2 - 52		
							QC 2 - 54		 DAS 5 9-89
							QC 2 - 56		
							QC 2 - 57		 DAS 5 9-89
							QC 2 - 62		
							QC 2 - 63		 DAS 5 9-89



Container No: S177706



Part: D4931 - 3

Job No: 188265

Serial No/Batch: S177706

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/03/19

				QC 2 - 8	
112	Conventional Mill - 1 - B4B	12 pcs	1/25/19	0.00 4.58	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
115	QC 2	12 pcs	1/25/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
120	QC 8	12 pcs	1/25/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
130	Packaging 3-2 - Stock - B4B	12 pcs	1/25/19	0.00 0.00	QC 8 - 1 (A)
					Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B

					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC MAY 15 2019 ST127
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS
					Packaging 3 - 36 - B4B	21
140 QC 21 - SA	12	1/25/19	0.00	0.00	QC 21 - SA - 21	9-55
	pcs				QC 21 - SA - 70	MAY 15 2019
Part Op 100 - Doosan Lathe)Machine as per folio FB210 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB) 112 - (Manufacture as per dwg)DRILL HOLES AS PER REQUIRED 115 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M303R2.000	303 Round Bar 2"	1.8000 ft (176 ea)	100-Doosan - 1	S166566		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Doosan - 1	M303R2.000	2	30	0		
Part Specifications						
Specifications could not be found.						

DART AEROSPACE LTD		Work Order: 88265
Description: EAPS P2 Engine Fitting		Part Number: D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.058	✓		Ut	
M.O.W.	Maj: 1.0995 Min: 1.0938	1.096	✓		wire .05	
0.13 x 45°	+/-0.030 x +/-0.5°	.135 x .08	✓			
Ø0.063	+0.004/-0.001	.065	✓			
0.08	+/-0.030	.072	✓			
0.906	+/-0.010	.911	✓			
0.13	+/-0.030	.13	✓			
0.25	+/-0.030	.254	✓			
0.938	+/-0.010	.943	✓			
1.927	+/-0.010	1.933	✓			
0.250	+/-0.010	.248	✓			
0.424	+/-0.010	.426	✓			
0.315	+/-0.010	.312	✓			
0.185	+/-0.010	.188	✓			
37°	+/-0.5°	37	✓			
0.33	+/-0.030	.345	✓			
34°	+/-0.5°	34°	✓			
0.532	+/-0.010	.5325	✓			
1.063	+/-0.010	1.061	✓			
0.594	+/-0.010	0.594	✓		Vener JVO5	
0.791	+/-0.010	.7905	✓		Vener JVO5	
1.188	+/-0.010	1.188	✓		Vener JVO5	
1.582	+/-0.010	1.583	✓		Vener JVO5	
0.238	+0.005 -0.001	0.238	✓		Vener JVO5	

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 19/05/14	Date: 19-05-14	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	[Signature]